



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3302-02-1
Job Sheet 179414



Part No: RBE350A93-3302-02-1

Job Qty: 18 ea

Part Name: Handle



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/30/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A93-3302-02-1 REV:11 IPP REV A 18.01.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea	7/30/18	7/30/18	0.00	0.00	Start Up Machining-4		
120	CNC Vertical Machining	18 pcs	7/30/18	7/30/18	1.50	3.00	MORI NV5000-1		
130	QC	18 pcs	7/30/18	7/30/18	0.00	0.00	QC2 Machining-5		
140	QC	18 pcs	7/30/18	7/30/18	0.00	0.00	QC8 Machining-5		
170	Outsource	18 pcs	7/30/18	7/30/18			GRO002-VC	10	
180	Packaging	18 pcs	7/30/18	7/30/18	0.00	0.00	Packaging2		
190	QC	18 pcs	7/30/18	7/30/18	0.00	0.00	QC6		
200	Packaging	18 pcs	7/30/18	7/30/18	0.00	0.00	Packaging3-2		
210	QC21-SA	18 Ea	7/30/18	7/30/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FB810 FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave T/N And
Descriptions: / or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water
sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required
200 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	18 ft (1 ea)	90-Start up Operation	590372

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	18	53	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

17:59 AM dart.logan.david

Container No: S112922



Part: RBE350A93-3302-02-1

Job No: 179414

Serial No/Batch: S112922

Revision: 11

Inspector:

Exp Date:

Instructions:

Date: 09/24/18

DART AEROSPACE LTD		Work Order:
Description: <i>Handle</i>		Part Number:
Inspection Dwg: <i>R3K 350 A93-330202</i> Rev: <i>11</i>		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.32	$\pm .01$	5.310			Vern L Pos	
4.850	$\pm .005$	4.852				
4.516	$\pm .005$	4.517				
3.07	$\pm .01$	3.065				
R.38	$\pm .01$	.375			Rad gage	
2.50	$\pm .01$	2.505			H.G.	
$\varnothing .25$	$\pm .01$	.252			Vern L Pos	
.75	$\pm .01$	.745				
$\varnothing .250$	$\pm .005$ / $- .000$	.252				
R.75	$\pm .01$	.750			Rad gage	
$.51 \times 45^\circ$	$\pm .01 \times .5^\circ$	$.510 \times 45^\circ$			Vern L Pos	
.602	$\pm .005$	.602				
.52	$\pm .01$	.518				
2.028	$\pm .005$	2.030				
11.81	$\pm .01$	11.802			H.G.	
3.669	$\pm .005$	3.669			Vern L Pos	
1.835	$\pm .005$	1.835				
$\varnothing .261$	$\pm .005$	.263				
.990	$\pm .01$	.983				
.990	$\pm .01$	.983				
R.125	$\pm .005$	.125				
.190	$\pm .005$	.192			H.g.	

Measured by: <i>P</i>	Checked by: <i>D.F.</i>	QC Inspector:
Date: <i>18-09-24</i>	Date: <i>18-09-24</i>	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

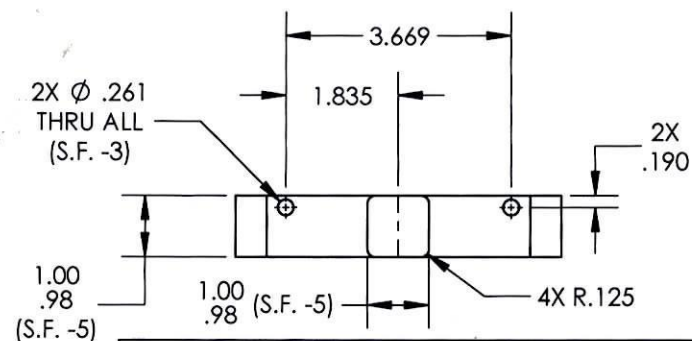
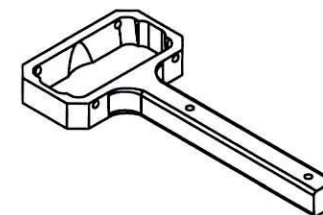
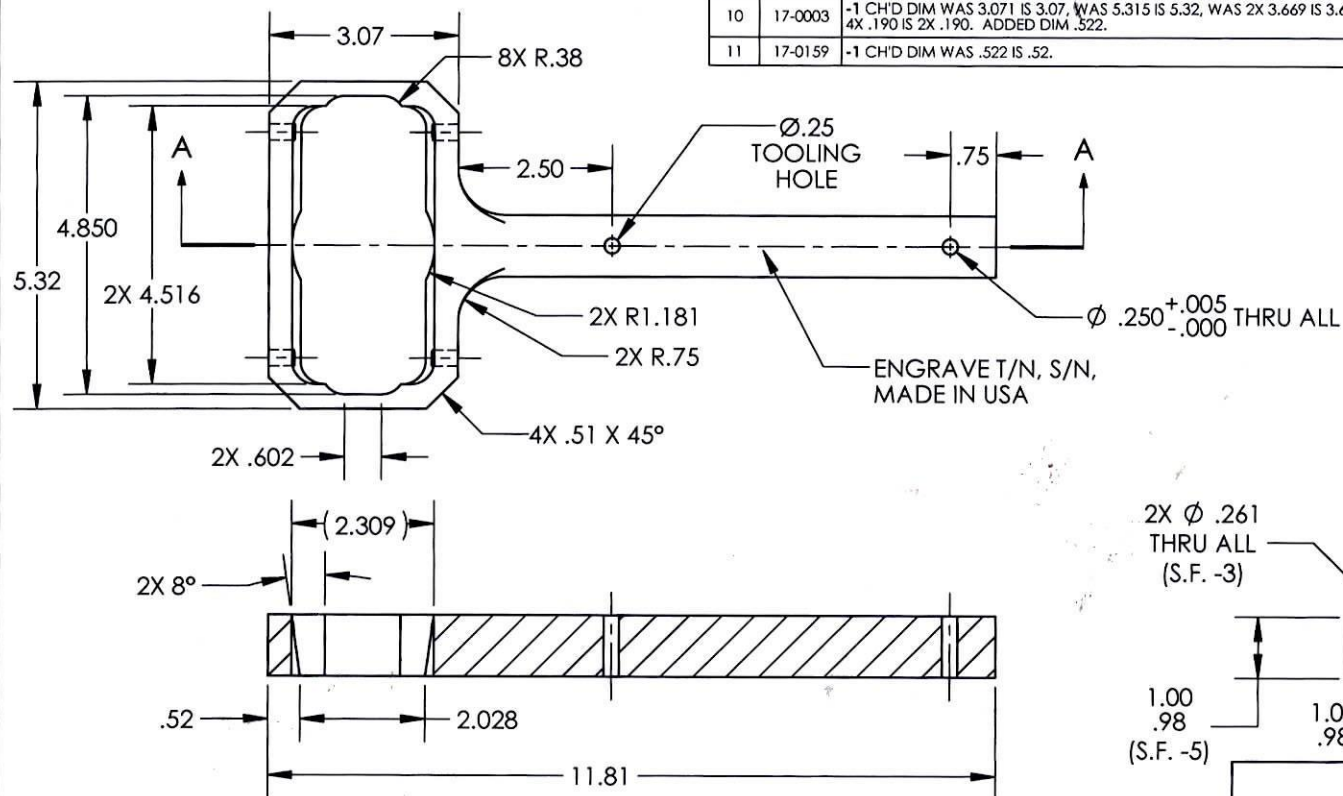
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D INSIDE ANGLED RADIUS FROM R.75 TO R.375, CH'D DIM WAS 1.122 IS 1.	12/5/2008	WP	DW
2		-1 ADDED Ø.250 HOLE.	3/18/2009	WP	DW
3		-1 ADDED 1 INCH SQUARE DIM, CH'D DIM TO 2.309.	4/29/2009	RJC	
5		-1 ADDED TOLERANCE 1.00 - .98 TO HANDLE.	10/6/2009	WP	DW
6		-1 CH'D TOOLING HOLE WAS Ø.266 IS Ø.250, ADDED ENGRAVE NOTE.	12/16/2010	RJC	RW
7		-1 CH'D DIM WAS Ø.250 IS Ø.250 +.005 -.000.	4/18/2013	CFS	JG
10	17-0003	-1 CH'D DIM WAS 3.071 IS 3.07, WAS 5.315 IS 5.32, WAS 2X 3.669 IS 3.669, WAS 2X 1.835 IS 1.835, WAS 4X .190 IS 2X .190. ADDED DIM .522.	2/28/2017	RJC	SM
11	17-0159	-1 CH'D DIM WAS .522 IS .52.	6/21/2017	RJC	JAG



SECTION A-A

①

HANDLE



TITLE	
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T/R HUB LOCK WRENCH

DWG NO.

RBE350A93-3302-02-1

REV	11
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MAT'L	6061
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HEAT _____

TREAT	
FINISH	BLACK ANODIZE

FINISH	BLACK ANODIZE
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SPEC MIL-A-8625F, TYPE II, CLASS II

DRAWN BY:	PERRITT
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CHECKED:	DUERFELD DT
----------	-------------

CHECKED:	DUERFELD
CRS APP:	ANDERSON

OPPS APPR:	ANDERSON
------------	----------

QA APPR:	LINDSAY
----------	---------

APPROVED:	MACKOV IAK
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APPROVED:	MACROVJAR
SCALE	DATE

SCALE	1:3	DATE
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	1.0	
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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
XXX ± .005 FRACTIONS ± 1/8
XX ± .01 ANGLES ± 5°
X ± .1 SURFACES = 125 ✓
BREAK ALL SHARP EDGES ✓

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY
AFTER PLATING

3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

EUROCOPTER AS350/355

EUROCOPTER AS350/355	
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/2008 | SHEET 2 OF 4

2000 SHEET 2 OF 4



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041118**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041118
PO Date: 9/24/18
Due Date: 9/25/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179414	RBE350A93-3302-02-1	Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93- 3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	-	9/25/18	2 pcs	0 pcs	2 pcs	\$75.00/pcs	\$150.00

JAS
38
9-89

Line Item Note **24 hour turn around please ** :)

Grand Total: \$150.00

GT



Dart Aerospace Ltd.
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PURCHASE ORDER PO041118

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/24/18 11:09 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916116

Date: 25-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: RBE350A93-3302-02-1 Handle Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Seal Job: 23793	Rev: 11	DAS 38 9-89
	PO: PO041118	Line: 1	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>25/9/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			